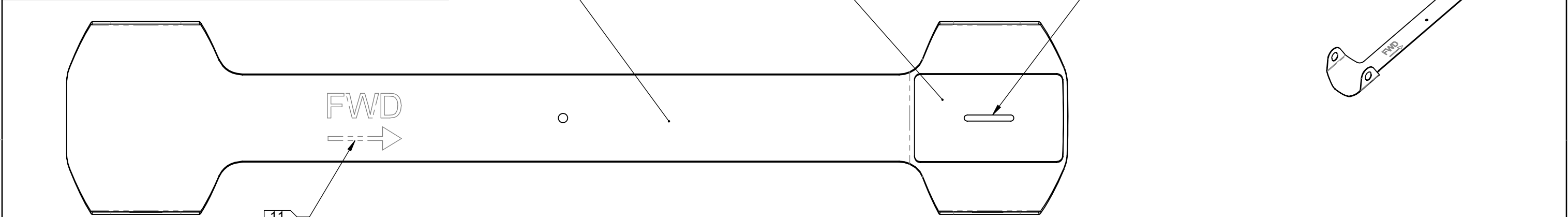
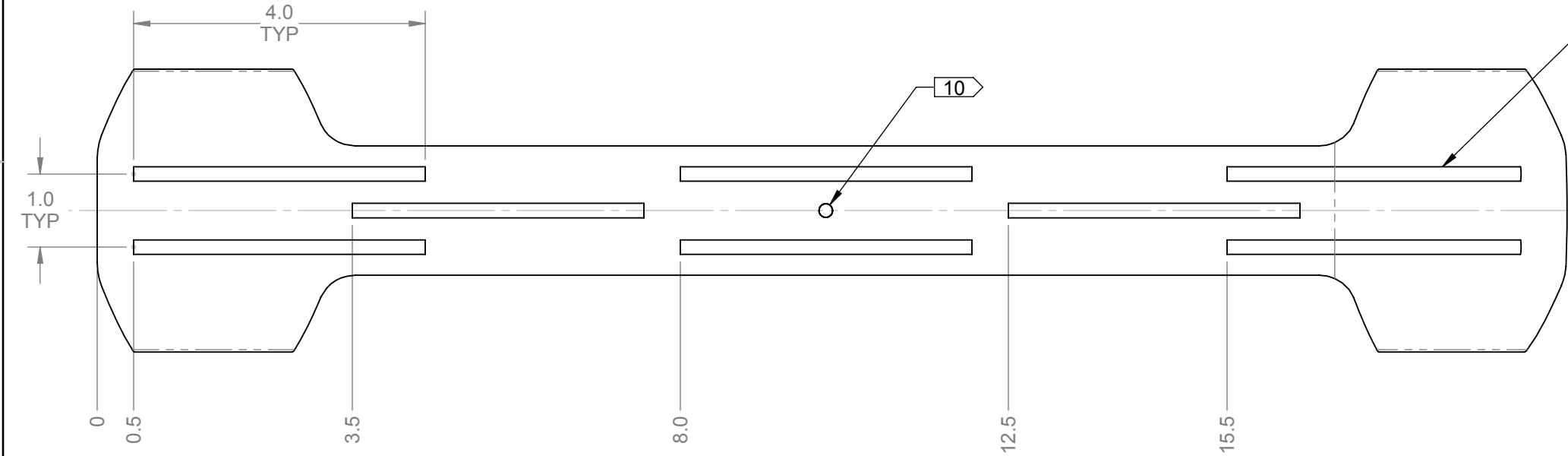


ITEM	QTY -041	P/N	DESCRIPTION
	X	D4682-041	WEARPLATE ASSY
1	1	D4682-1	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM
3	A/R	8259/2059B	HARDCOAT WELD



D4682-041 WEARPLATE ASSY



D4682-041 WEARPLATE ASSY
(WELD BEAD DETAIL)

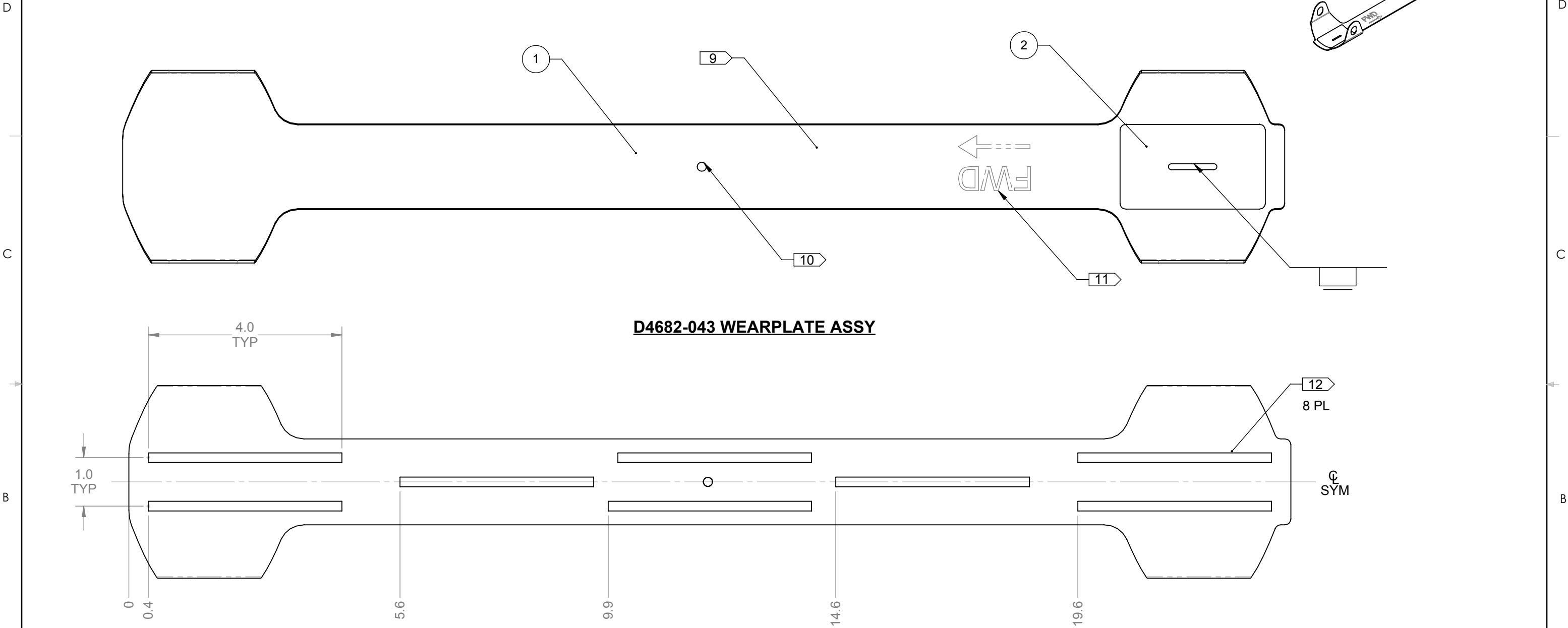
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 1.06 lbs
 - 8) WELDING: PER QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
 - 10) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING
 - 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER
 - 12) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

E	WELDING NOTES UPDATED FOR AUTOMATED WELDING. MINOR DIMENSIONAL CHANGES TO FACILIATATE INSPECTIONS. MOVED WELD BEAD DETAILS TO ASSEMBLIES.	AP	15.10.19
D	ADDED SHT 2, WEARPLATE FORMING MODIFIED TO ACCOMODATE MATERIAL SPRING BACK, ADD FWD BEND TO D4682-041, MINOR DIM CHANGES, D4682-9 RE-DESIGNED, D4682-11 REMOVED, ADD FWD INDICATION TO D4682-045/-7	AP	15.03.24
C	ADDED FWD INDICATION ON D4682-041/-043 PER NOTE 11 (SHT 1), D4682-11 SHIM (SHT 8) REPLACED D4769-3 SHIM, VARIOUS DIMENSIONAL CHANGES TO THRU HOLES AND OVERALL DIMENSIONS OF D4682-1/-3/-5/-9 PARTS. REFERENCE TO PLUS ONE ROCKGUARD REMOVED.	AP	14.07.29
B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, Ø0.188 HOLE MOVED (B5-3), UPDATED PART WEIGHTS, REMOVED GRAIN DIR ON ALL PARTS D4769-3 WAS D4682-9 ON D4682-041 WEARPLATE ASSY.	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
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CHECKED	AJS	DRAWING NO.	REV. E4
MFG. APPR.	DD	D4682	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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PRELIMINARY ISSUE

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4682-043	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM
3	A/R	8259/2059B	HARDCOAT WELD



D4682-043 WEARPLATE ASSY

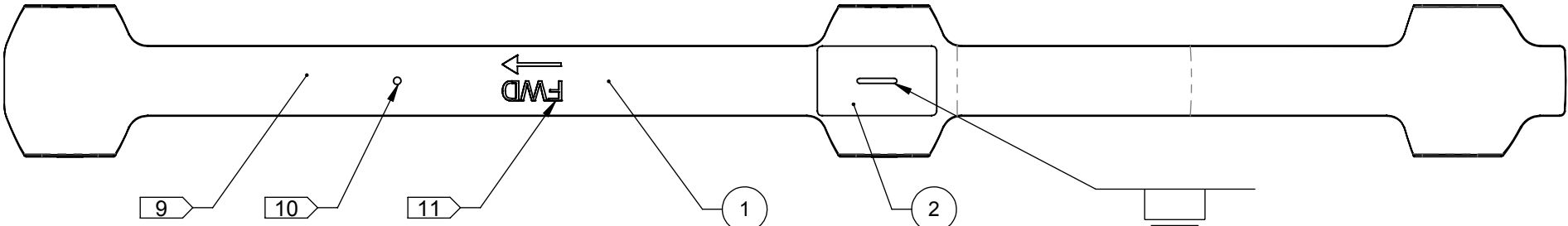
D4682-043 WEARPLATE ASSY
(WELD BEAD DETAIL)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 1.20 lbs
 - 8) WELDING: PER QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
 - 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
 - 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER
 - 12) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

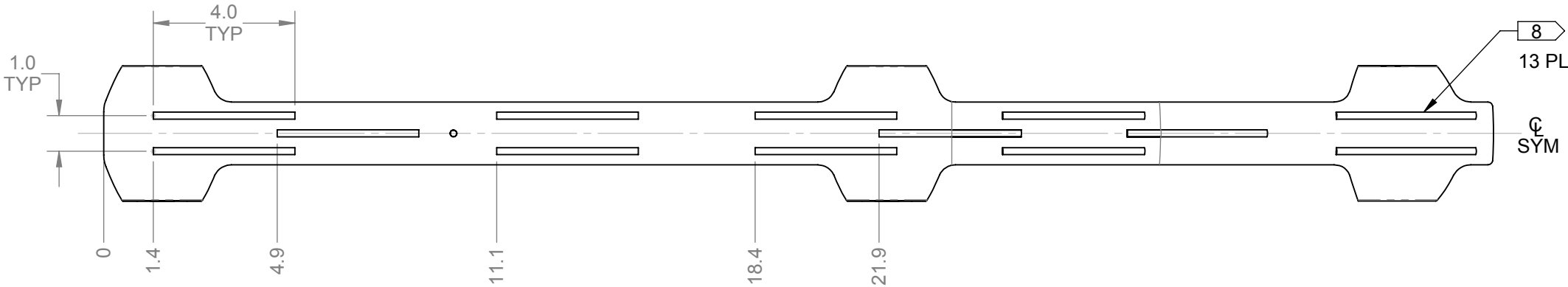
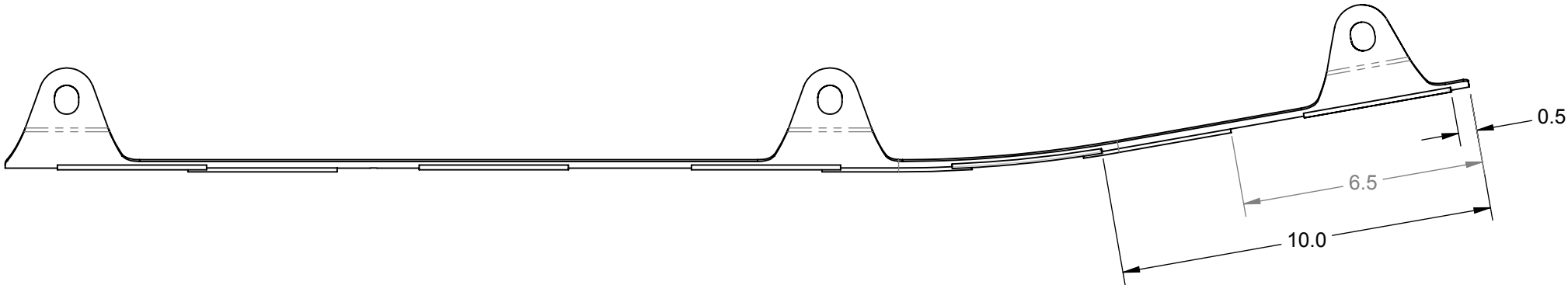
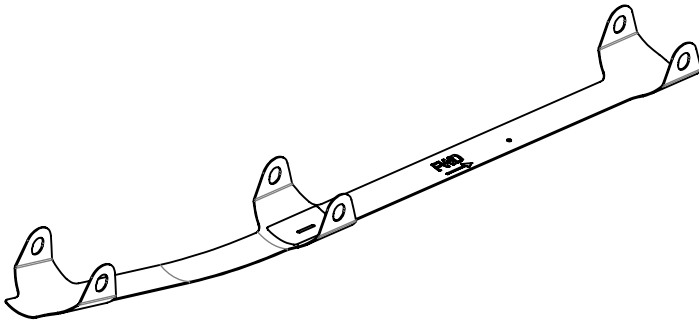
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ITEM	QTY	P/N	DESCRIPTION
	045		
	X	D4682-045	WEARPLATE ASSY
1	1	D4682-5	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM
3	A/R	8259/2059B	HARDCOAT WELD



D4682-045 WEARPLATE ASSY



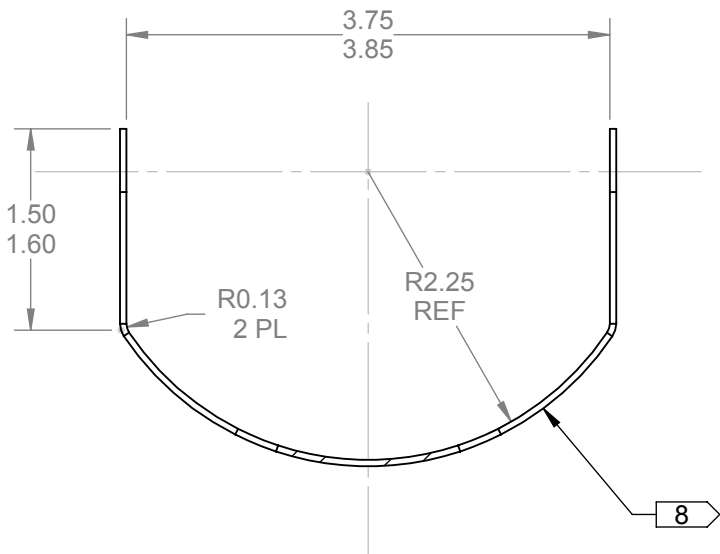
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.85 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER
- 12) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

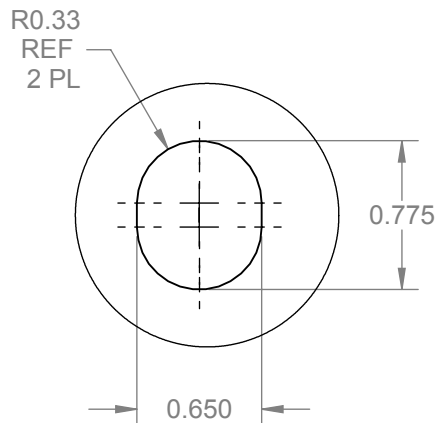
D4682-045 WEARPLATE ASSY
(WELD BEAD DETAIL)

PRELIMINARY ISSUE

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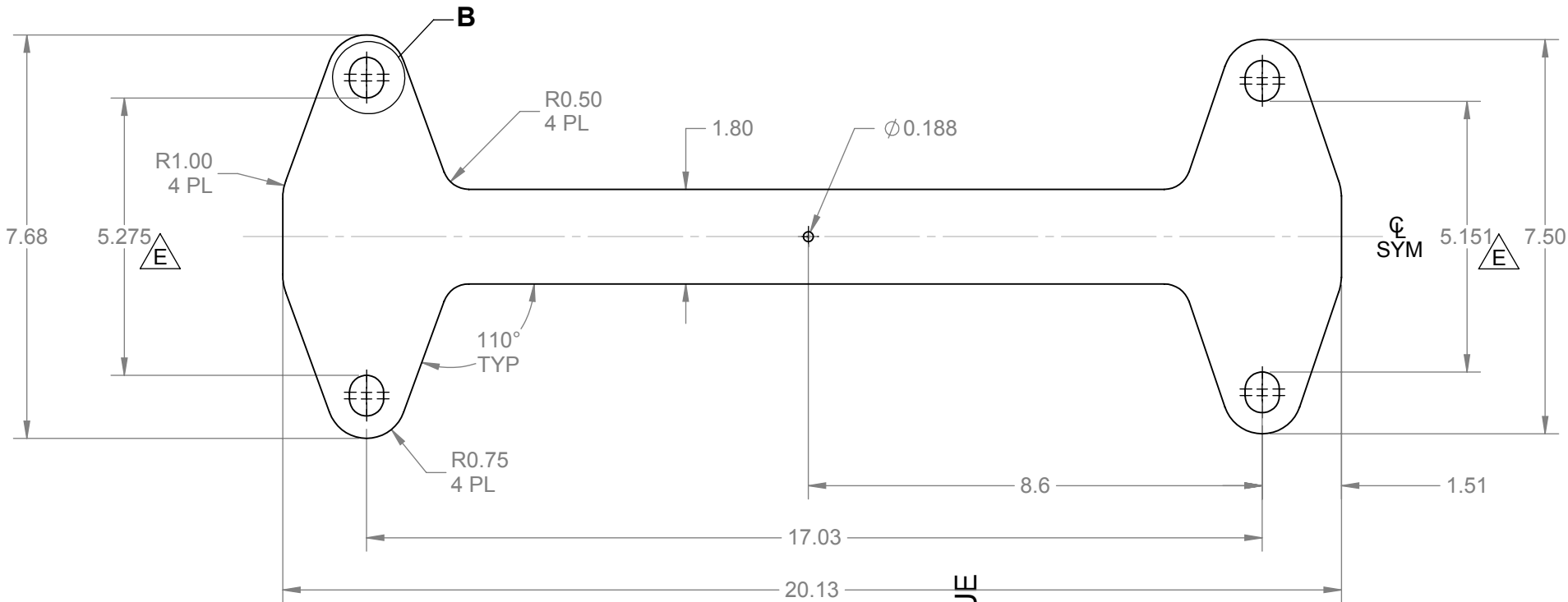
SECTION A-A
SCALE 2X



DETAIL B
SCALE 3X
4 PL



D4682-1 WEARPLATE
(MAKE FROM D4682-1F)

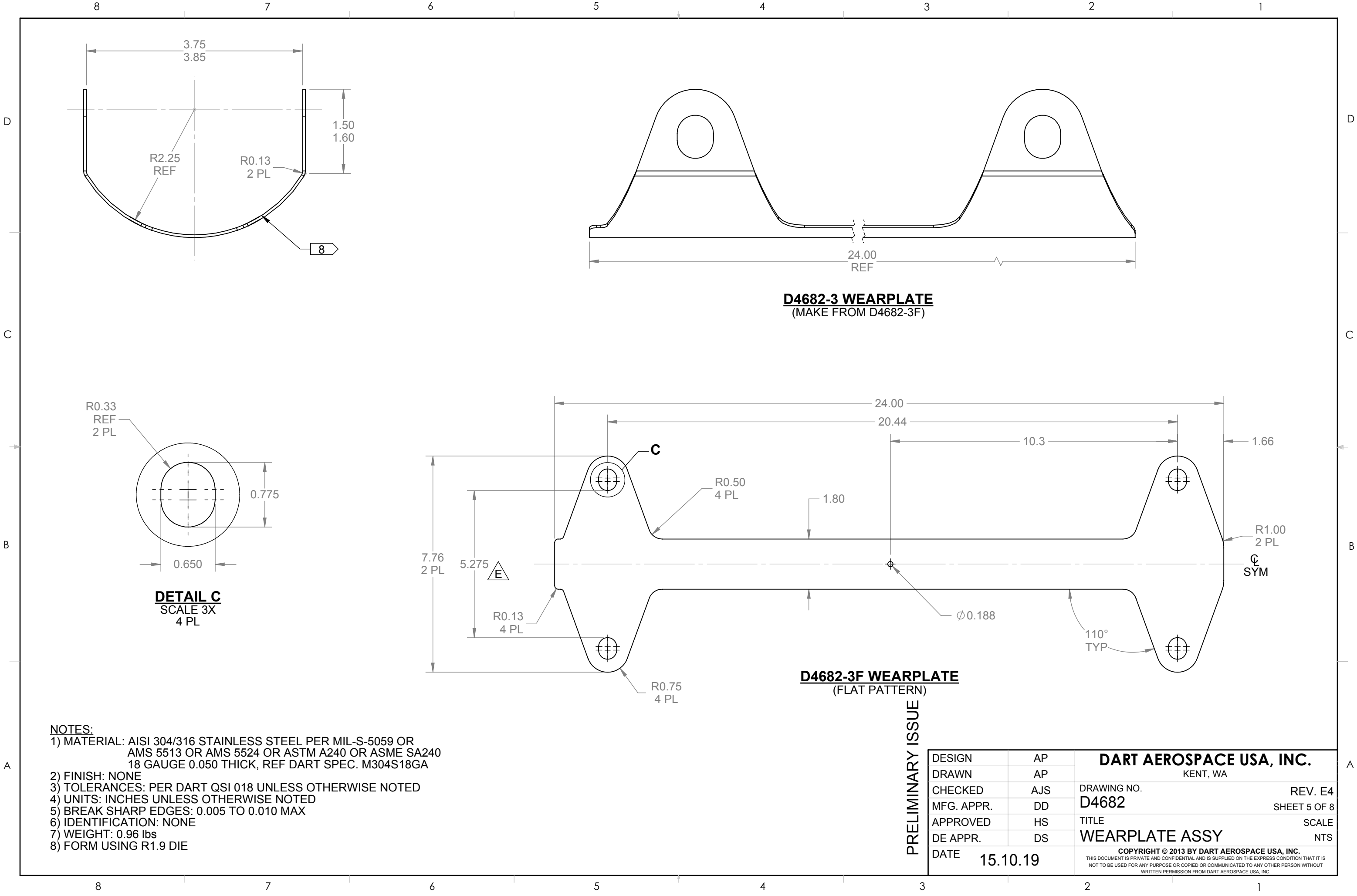


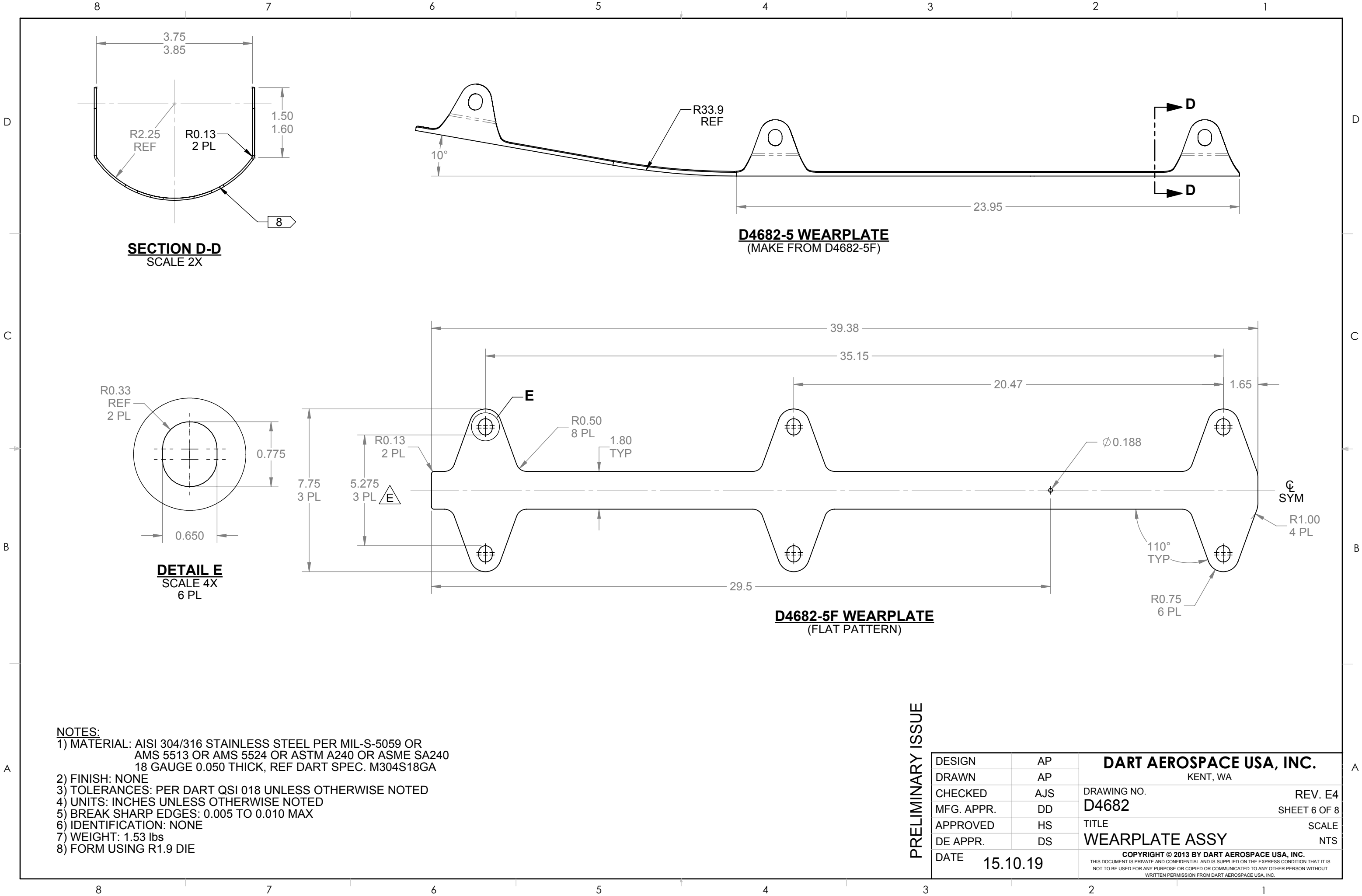
D4682-1F WEARPLATE
(FLAT PATTERN)

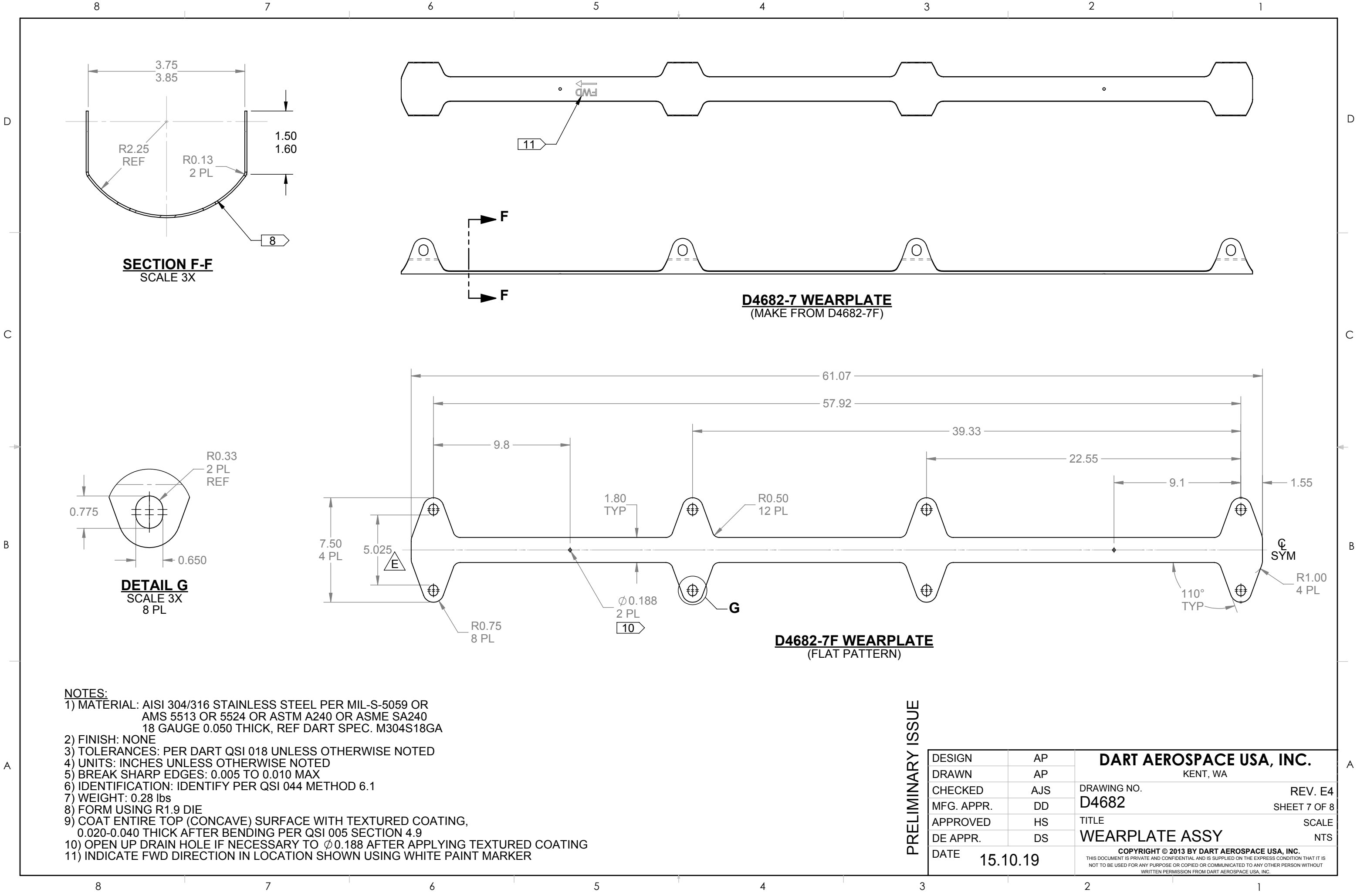
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs
 - 8) FORM USING R1.9 DIE

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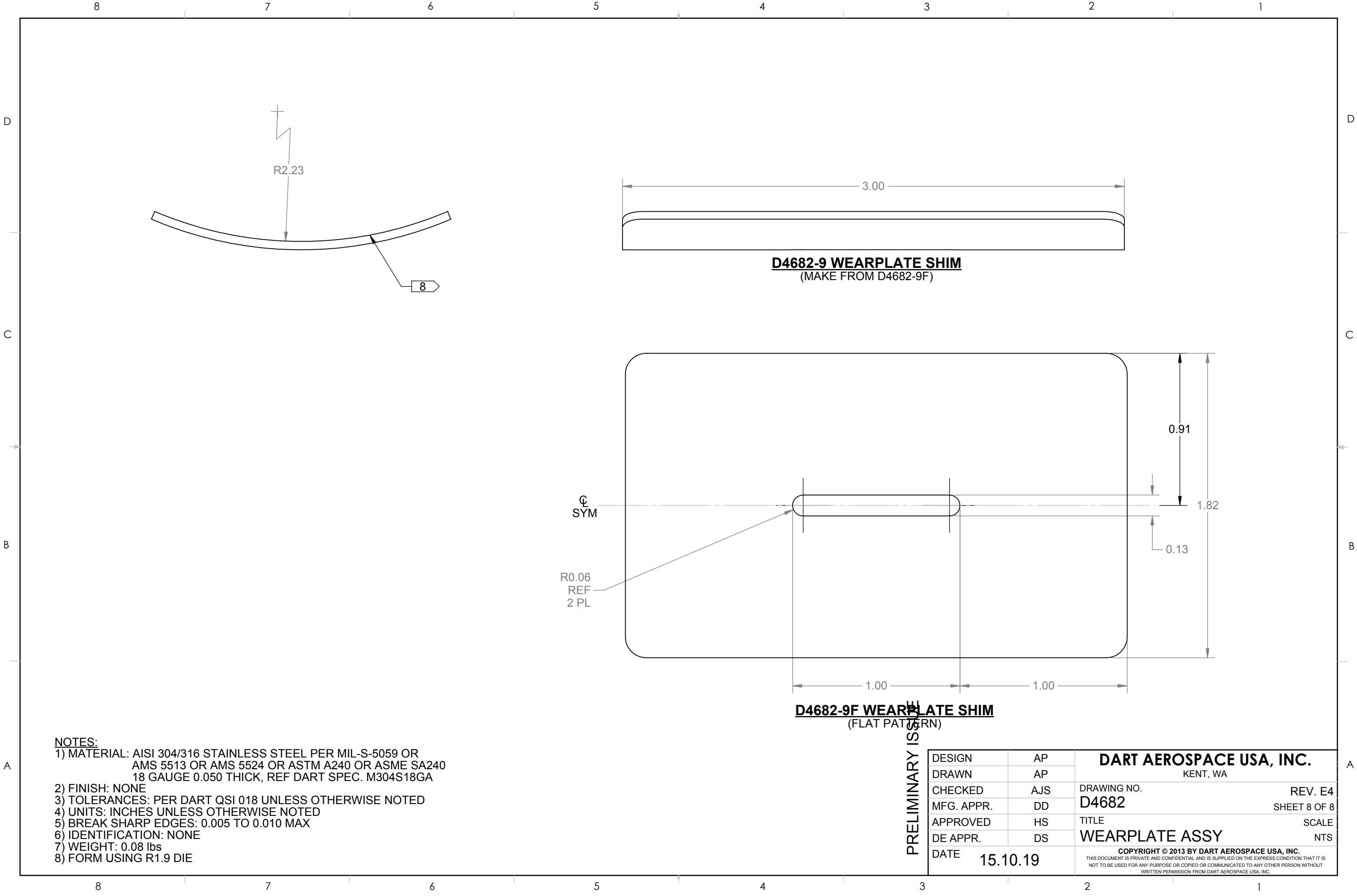


NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.28 lbs
- 8) FORM USING R1.9 DIE
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK AFTER BENDING PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) FORM USING R1.9 DIE

PRELIMINARY ISG

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D4682	REV. E4 SHEET 8 OF 8
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DE APPR.	DS		
DATE	15.10.19		